

Date: Wednesday, 11/04/2007 8:57:13 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D3537-3	
Job Number	: 31742		Part Number	: D35373	
Estimate Number	: 10804		Drawing Number	: CUSTOM-H/D WELDS	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 11/04/2007 S.O. No. : N/A		Drawing Revision	: N/A	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 13/04/2007 Qty: 2 Um: Each	
Previous Run	: 31741				
Written By	:				
Checked & Approved By	:				
Comment	:				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	HAND FINISHING1	HAND FINISHING RESOURCE #1  <div style="text-align: right; border: 1px solid black; border-radius: 50%; padding: 5px; margin-top: 10px;">2x</div>
<b>Comment:</b> HAND FINISHING RESOURCE #1 PULL FROM STOCK 2 X D3537-3 B <u>31742</u> B30758		
REMOVE PAINT WITH PAINT STRIPPER  <div style="text-align: right; border: 1px solid black; border-radius: 50%; padding: 5px; margin-top: 10px;">2x</div>		
2.0	D35373	WEARPAD  <div style="text-align: right; border: 1px solid black; border-radius: 50%; padding: 5px; margin-top: 10px;">2x</div>
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) WEARPAD		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1  <div style="text-align: right; border: 1px solid black; border-radius: 50%; padding: 5px; margin-top: 10px;">2x</div>
<b>Comment:</b> LARGE FABRICATION RESOURCE 1 CLEAN PROPERLY WITH A WIRE BRUSH		
4.0	QC5	INSPECT WORK TO CURRENT STEP  <div style="text-align: right; border: 1px solid black; border-radius: 50%; padding: 5px; margin-top: 10px;">2x</div>
<b>Comment:</b> INSPECT WORK TO CURRENT STEP		
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1  <div style="text-align: right; border: 1px solid black; border-radius: 50%; padding: 5px; margin-top: 10px;">2x</div>
<b>Comment:</b> LARGE FABRICATION RESOURCE 1		
WELD AS PER DRWG D3537 - MARKED UP BY SERGE HEAVY DUTY HARD FACING A7560/3-2 B <u>102755</u>		
<div style="text-align: right; margin-top: 20px;">FC 07/04/12 (2)</div>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/04/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/04/2007 8:57:13 AM  
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Drawing Name: D3537-3

Job Number: 31742

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5/9 WELD INSPECTION



11/04/12 (2)

Comment: WELD INSPECTION

7.0 POWDER COATING POWDER COATING



(2X)

M19720

Comment: POWDER COATING

REPAINT GREY SANTEX PER QSI 005

m-l

07/04/12

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

4 07/04/12

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



see

30967A

968A

Comment: HAND FINISHING RESOURCE #1

RESTOCK USING NEW B/N

USE FOR TUBES - 30967A & 30968A ONLY

6 38.04.13 30967A  
30968A

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(2)  
10/04/13

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



6 39.04.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

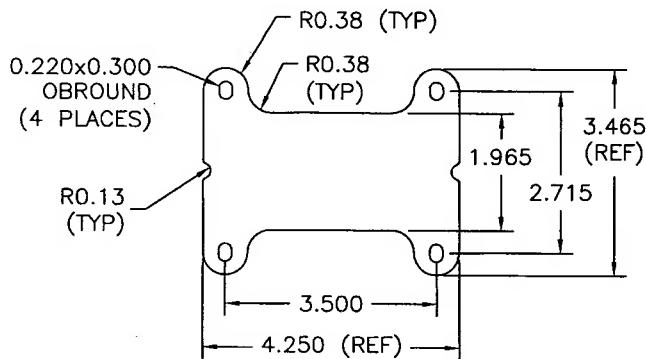
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

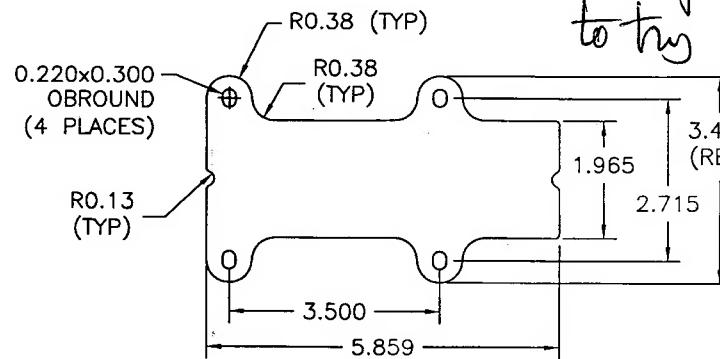
NOTE: Date & initial all entries

30967A  
30968A

D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

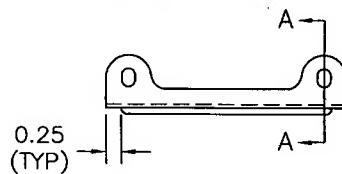


*Additional Welds  
are for customer  
to try and give  
VS a feedback*

*AS Per Bill  
Beckett,*  
*Not*

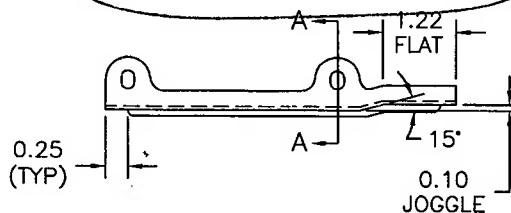
SECTION A-A  
R1.62  
0.50  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.063 TO 0.125 THICK

D3537-1 LONGITUDINAL BEND  
(MADE FROM D3537-1F)

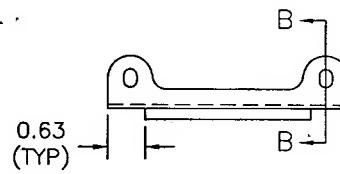


RELEASED  
07.02.12

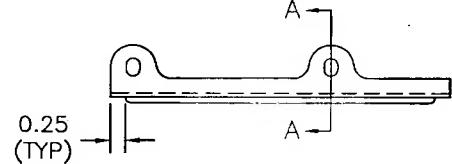
D3537-3 LONGITUDINAL BEND  
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND  
(MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND  
(MADE FROM D3537-3F)



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE  
(0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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A	06.11.06	NEW ISSUE
DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HULOCK, WA
CHECKED PH	APPROVED H	DRAWING NO. D3537
DATE 06.11.06	TITLE WEARPAD	REV. A SHEET 1 OF 1 SCALE 1:2